

Work Order ID 127849-2

December-17-14 1:57:23 PM

\*127849\*

Page 1

Item ID: D4436-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Bracket Assembly

Start Date: 1/13/15 Start Qty: 2.00

Required Date: 1/13/15 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 14-12-23

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4436

A

100

0.00

\*100\*

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and intall grommet

2x DAS 28 FEB 11 2015  
9-89

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

Memo

0.00

Quality Control

(2) DAS 38 MAR 09 2015  
9-89

160

Identify as per dwg &amp; Stock Location: 3623

0.00

\*160\*

Packaging

Memo

0.00

Packaging

2 MAR 10 2015

DAS 36  
9-89

MF  
15-3-0

1000  
1002  
1004

1000

1000

December-17-14 1:57:21 PM

**Parent Item Name:** Aft Bracket Assembly

\*D4436-041\*

**Required Qty: 2.00**

IPP  
IPP REV:C

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty    | Qty<br>Issued | Date<br>Issued | Status      |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|-------------|
| D4440-1                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 10.0000        | 1           | 76              |               |                |             |
| *D4440-1*                       |                        |               |             |                     |                  |                 |                    |                | **          |                 |               | DAS            | FEB 11 2015 |
| Grommet                         |                        |               |             |                     |                  |                 |                    |                |             |                 |               | 28             |             |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |                 |               | 9-89           |             |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |             |
|                                 |                        |               |             | GA                  |                  |                 |                    | 10             |             |                 |               |                |             |
|                                 |                        |               |             |                     | 120257           |                 |                    | 10             |             | 127830 X 4      |               |                |             |
|                                 |                        |               |             |                     |                  |                 |                    |                |             | 129462 X 2      |               |                | MAR 09 2015 |
| D4435-043                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 11.0000        | 1           | 76              |               |                |             |
| *D4435-043*                     |                        |               |             |                     |                  |                 |                    |                | **          |                 |               | DAS            |             |
| Mount Bracket Assembly          |                        |               |             |                     |                  |                 |                    |                |             |                 |               | 28             |             |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               | 9-89           |             |
|                                 |                        |               |             | ST107               |                  |                 |                    | 11             |             |                 |               |                |             |
|                                 |                        |               |             |                     | 125065           |                 |                    | 3              |             |                 |               |                |             |
|                                 |                        |               |             |                     | 126470           |                 |                    | 8              |             | 6               |               |                |             |
| D4436-043                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 0.0000         | 1           | 76              |               |                |             |
| *D4436-043*                     |                        |               |             |                     |                  |                 |                    |                | **          |                 |               | DAS            |             |
| Aft Outboard Bracket Assembly   |                        |               |             |                     |                  |                 |                    |                |             | 128275          |               | 28             |             |
| D4436-045                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 1.0000         | 1           | 76              |               | 9-89           |             |
| *D4436-045*                     |                        |               |             |                     |                  |                 |                    |                | **          |                 |               | DAS            |             |
| Aft Inboard Bracket Assembly    |                        |               |             |                     |                  |                 |                    |                |             |                 |               | 28             |             |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               | 9-89           |             |
|                                 |                        |               |             | ST620               |                  |                 |                    | 1              |             | 125276          |               |                |             |
|                                 |                        |               |             |                     | 123050           |                 |                    | 1              |             |                 |               |                |             |

1000 0000 0000

# Picklist Print

December-17-14 1:57:22 PM

Page 2

Work Order ID: 127849

Parent Item: D4436-041

Parent Item Name: Aft Bracket Assembly

**\*127849\***

**\*D4436-041\***

Start Date: 1/13/15

Required Date: 1/13/15

Start Qty: 2.00

Required Qty: 2.00

AN525-832R6

Purchased

No

100

Each

212.0000

4

824

**\*AN525-832R6\***

Screw

**\*\***

DAS

28

9-89

FEB 11 2015

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

12

125303

12

ST329

186

m130325

66

m130466

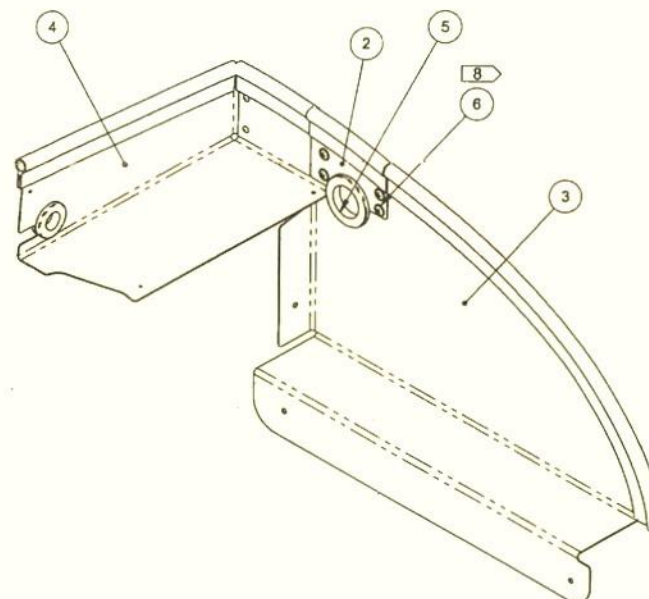
120

24





| ITEM | QTY<br>-041 | PART NUMBER | DESCRIPTION                   |
|------|-------------|-------------|-------------------------------|
| 1    | X           | D4436-041   | AFT BRACKET ASSEMBLY          |
| 2    | 1           | D4435-043   | BRACKET ASSEMBLY              |
| 3    | 1           | D4436-043   | AFT OUTBOARD BRACKET ASSEMBLY |
| 4    | 1           | D4436-045   | AFT INBOARD BRACKET ASSEMBLY  |
| 5    | 1           | D4440-1     | GROMMET                       |
| 6    | 4           | AN525-832R6 | SCREW                         |



**D4436-041 AFT BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

|            |                    |    |          |
|------------|--------------------|----|----------|
| A          | NEW ISSUE          | RF | 12.01.17 |
| REV.       | DESCRIPTION        | BY | DATE     |
| DESIGN     | RF                 |    |          |
| DRAWN      | RF                 |    |          |
| CHECKED    | <i>[Signature]</i> |    |          |
| MFG. APPR. | <i>[Signature]</i> |    |          |
| APPROVED   | <i>[Signature]</i> |    |          |
| DE APPR.   | <i>[Signature]</i> |    |          |
| DATE       | 12.01.17           |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

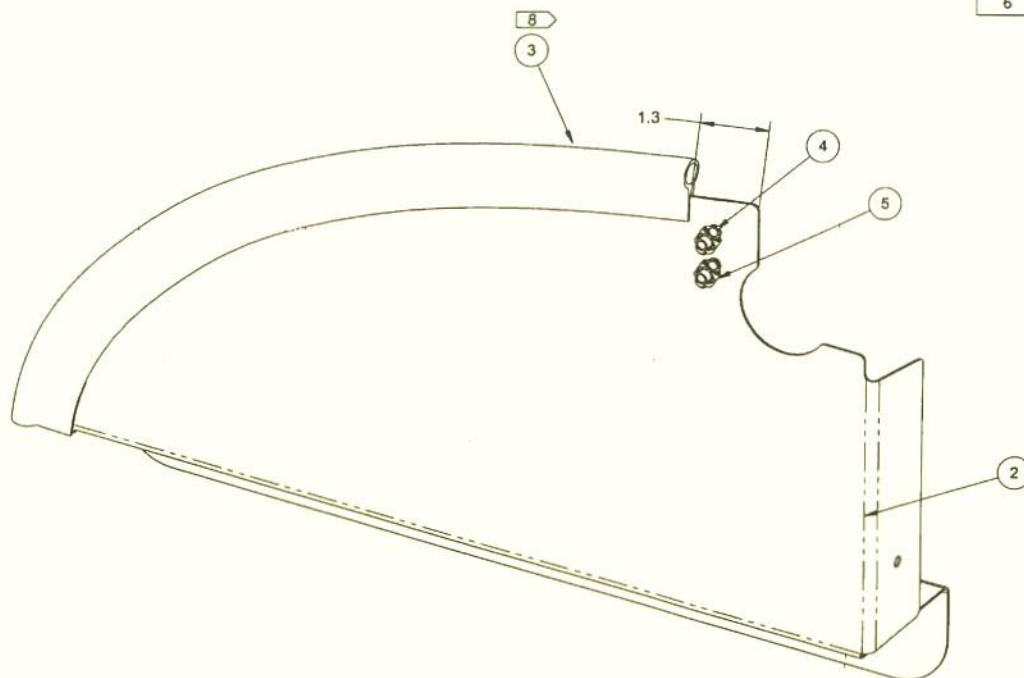
DRAWING NO. **D4436** REV. A  
SHEET 1 OF 7  
TITLE **COVER ASSEMBLY** SCALE NTS

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| ITEM | QTY<br>.043 | PART NUMBER   | DESCRIPTION                   |
|------|-------------|---------------|-------------------------------|
| 1    | X           | D4436-043     | AFT OUTBOARD BRACKET ASSEMBLY |
| 2    | 1           | D4436-1       | BRACKET                       |
| 3    | 1           | D4441-1-160   | RUBBER SEAL                   |
| 4    | 4           | MS20426AD3-2  | RIVET                         |
| 5    | 2           | MS21075L08    | NUT PLATE                     |
| 6    | A/R         | 3M 1300/1300L | ADHESIVE                      |



**D4436-043 AFT OUTBOARD BRACKET ASSEMBLY**

**NOTES:**

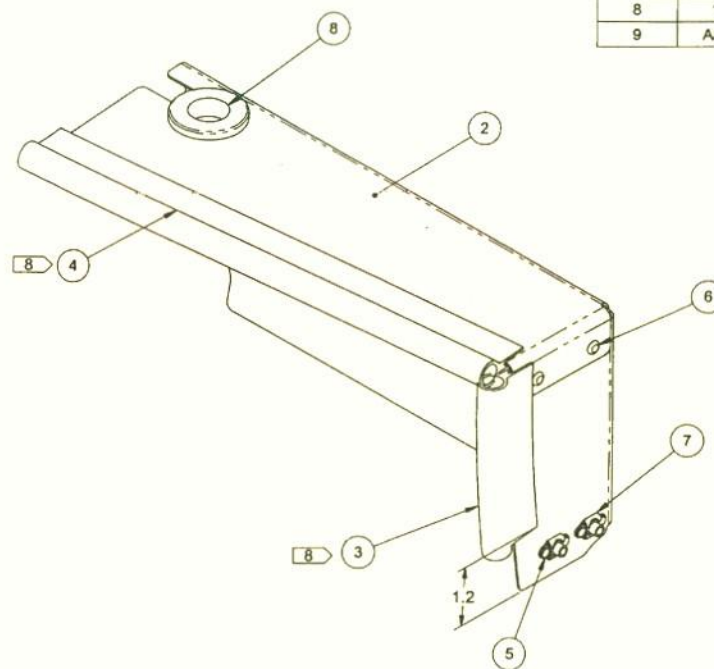
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL. IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

|            |                    |                                                                                                                                                                                                                                                                                        |              |
|------------|--------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                               |              |
| DRAWN      | RF                 |                                                                                                                                                                                                                                                                                        |              |
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| MFG. APPR. | <i>[Signature]</i> | D4436                                                                                                                                                                                                                                                                                  | SHEET 2 OF 7 |
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2012-01-23



| ITEM | QTY<br>-045 | PART NUMBER   | DESCRIPTION                  |
|------|-------------|---------------|------------------------------|
| 1    | X           | D4436-045     | AFT INBOARD BRACKET ASSEMBLY |
| 2    | 1           | D4436-3       | BRACKET                      |
| 3    | 1           | D4441-1-038   | RUBBER SEAL                  |
| 4    | 1           | D4441-1-100   | RUBBER SEAL                  |
| 5    | 4           | MS20426AD3-2  | RIVET                        |
| 6    | 2           | MS20470AD4-3  | RIVET                        |
| 7    | 2           | MS21075L08    | NUT PLATE                    |
| 8    | 1           | MS35489-19    | GROMMET                      |
| 9    | A/R         | 3M 1300/1300L | ADHESIVE                     |



**D4436-045 AFT INBOARD BRACKET ASSEMBLY**

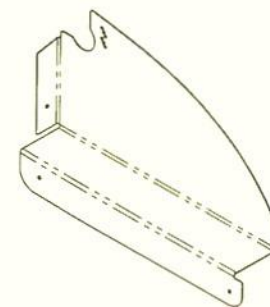
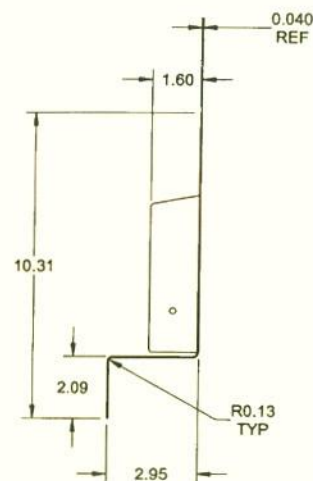
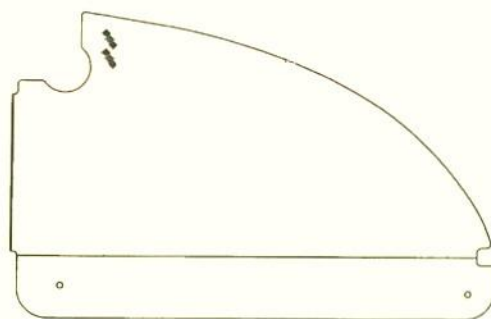
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

|            |                    |                                                                                                                                                                                                                                                                                                  |              |
|------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
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| MFG. APPR. | <i>[Signature]</i> | D4436                                                                                                                                                                                                                                                                                            | SHEET 3 OF 7 |
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2012-01-23  
*[Signature]*





**D4436-1 BRACKET**

**NOTES:**

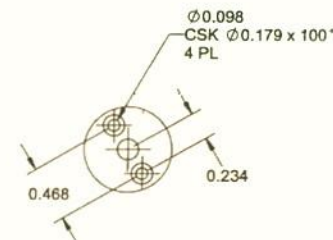
- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

|            |                    |                                                                                                                                                                                                                                                                                          |              |
|------------|--------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |              |
| DRAWN      | RF                 |                                                                                                                                                                                                                                                                                          |              |
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| MFG. APPR. | <i>[Signature]</i> | <b>D4436</b>                                                                                                                                                                                                                                                                             | SHEET 4 OF 7 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
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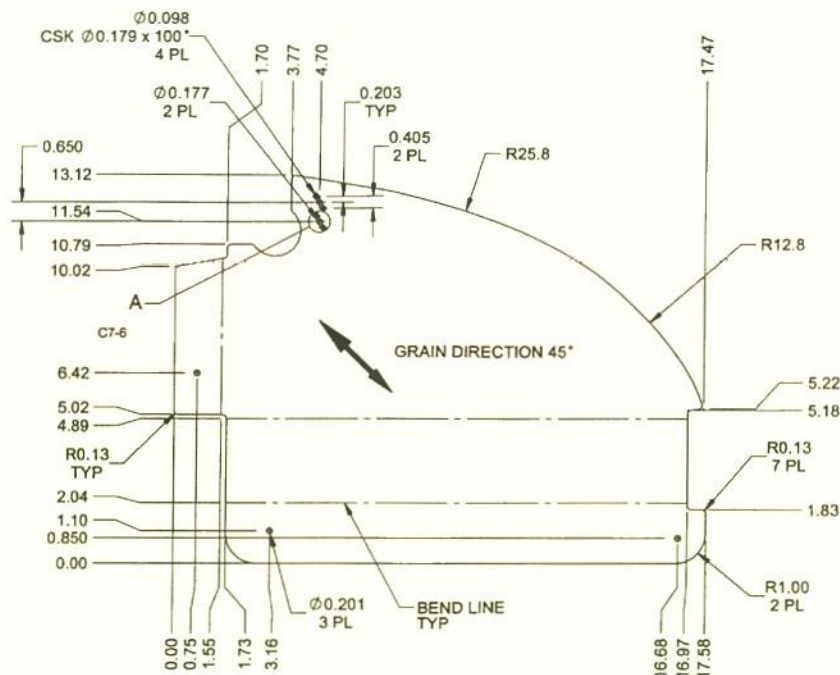
RELEASE  
2012-31-23  
*[Signature]*







DETAIL A C8-6  
SCALE 4X, TYP



**D4436-1F FLAT PATTERN**

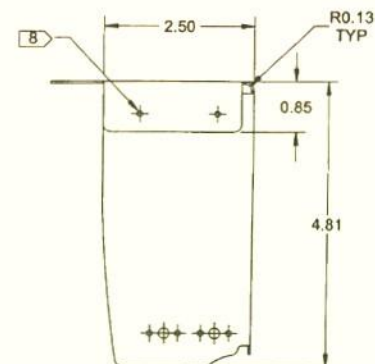
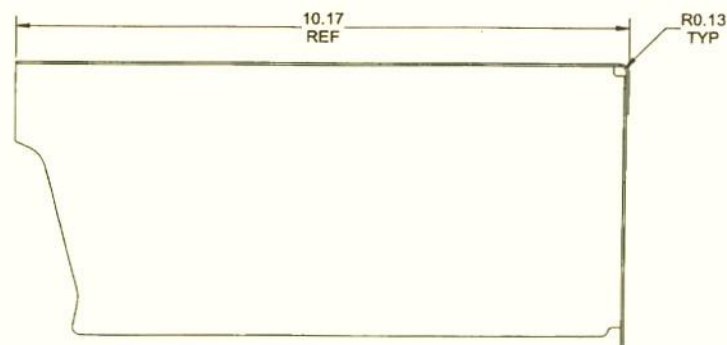
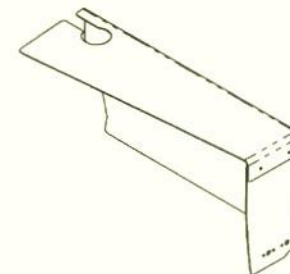
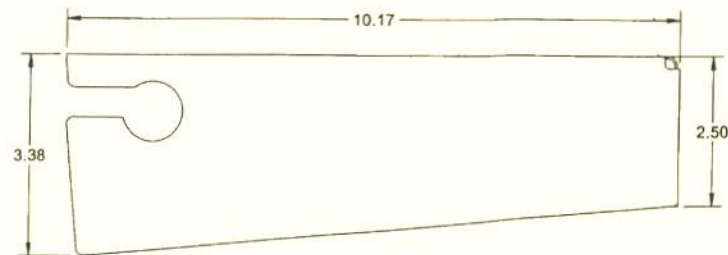
**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

|            |                    |                                                                                                                                                                                                                                                                               |        |
|------------|--------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                      |        |
| DRAWN      | RF                 |                                                                                                                                                                                                                                                                               |        |
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| MFG. APPR. | <i>[Signature]</i> | SHEET 5 OF 7                                                                                                                                                                                                                                                                  |        |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                         | SCALE  |
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# **D4436-3 BRACKET**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER  $\varnothing 0.129$  HOLES THRU 2 PLACES

|            |                    |                                                                                                                                                                                                                                                                                        |              |
|------------|--------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                               |              |
| DRAWN      | RF                 |                                                                                                                                                                                                                                                                                        |              |
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| MFG. APPR. | <i>[Signature]</i> | <b>D4436</b>                                                                                                                                                                                                                                                                           | SHEET 6 OF 7 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | <b>COVER ASSEMBLY</b>                                                                                                                                                                                                                                                                  | NTS          |
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